



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D2274

Job Sheet 170095



215

Part No: D2274

Job Qty: 200 ea

Part Name: Radius Block



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 1/10/18

Job Tracking No:

Due Date: 1/19/18

Created By: Linda Lacelle

Type: Stock

Description:

Customer: Rilpa Enterprises Ltd (CRILP01)

480 Aviation Way NE Calgary, AB, T2E 7G3 Canada ph:(403) 275-3035 fx:(403) 730-0170.

Note: DWG REV F IPP H 00.05.18 Added inspection level 8 EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	200 Ea		1/18/18	0.00	0.00	Start Up Large Fab-7		
100	Shear	200 pcs		1/18/18	0.00	0.10	Shear		
110	CNC Vertical Machining	200 pcs		1/18/18	0.01	4.79	HAAS 1		
130	QC	200 pcs		1/18/18	0.00	0.00	QC8		FR 18-1-24
140	Small Fab	200 pcs		1/18/18	0.00	1.08	Small Fab		MLL 18-01-31
150	HandFinish	200 pcs		1/19/18	0.00	0.51	HandFinish1		18-01-31
160	QC	200 pcs		1/19/18	0.00	0.00	QC7		BEB 18-01-31
170	Packaging	200 pcs		1/19/18	0.00	0.00	Packaging3		502
180	QC21-SA	200 Ea		1/19/18	0.00	0.00	QC21		18/02/01

Part Op 100 - blanks 9.00" long +/- 0.030" Note: 1 blank makes 9 pieces

Descriptions: 110 - Machine as per folio D2274

140 - Tumble Deburr any rough edges after tumbling

DAS
21
9-00

FEB 02 2018

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	M6061T6B00750X00.125	17	61	0	0

M6061T6B00750X00.125
S010026

DART
AEROSPACE
S034198



Radius Block

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CANADA
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PART NO: D2274
Original Serial #: S034198
Revision:
Operation:
Change No:

Start up Operation

01/22/18
Job No: 170095

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Radius Block	0.257inches + 0.005 - 0.000	0.262 0.257		
2	Radius Block	0.750inches ± 0.010	0.760 0.740		
3	Radius Block	0.375inches ± 0.010	0.385 0.365		
4	Radius Block	0.125inches ± 0.010	0.135 0.115		
5	Radius Block	0.750inches ± 0.010	0.760 0.740		
6	Radius Block	0.063inches ± 0.010	0.073 0.053		

Plex 1/10/18 7:48 AM dart.lacelle.linda

1/10/18
362 F 100
1/10/18 12:48 PM

